

Work Order ID 64294

Wednesday, December 01, 2010 1:22:43 PM

Page 1

Item ID: D3838-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 12/1/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: 111585

5- c/sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: 111585

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

SAD 10-12-02

PPL 10-10-07

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64294

Wednesday, December 01, 2010 1:22:43 PM

Page 2

Item ID: D3838-041

Accept

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Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 12/1/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				2	Ø	3E10/12/08	
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(+2) 2641			
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				(2)			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 64294

Page 3

Wednesday, December 01, 2010 1:22:43 PM

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, L.H.)

Start Date: 12/1/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09 *[Signature]*
ME
10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, December 01, 2010 1:22:47 PM

Page 1

Work Order ID: 64294

Parent Item: D3838-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 12/1/2010

Required Date: 12/8/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Manufactured No



Bushing

Each 23.0000 1



Cpl 10.12.07

Location Loc Qty Loc Code

ST084 3

56942 3

WA 20

54072 9

6387 11

M304TS0.750W.065 Purchased No



304 SQ Tube .75x.75x.065W

100 f 1,062.852 1.0317



B63870 → ②

SAD 10-12-02

2.172

Location Loc Qty Loc Code

MAT 1015.74795

112398 0

115494 4.4725

115593 11.27545

116267 1000

WA 47.104485

115274 4.712185

115901 42.3923

2.172

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

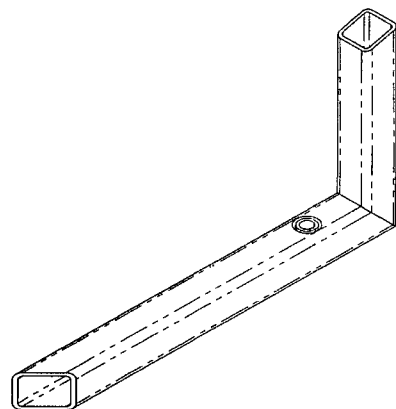
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

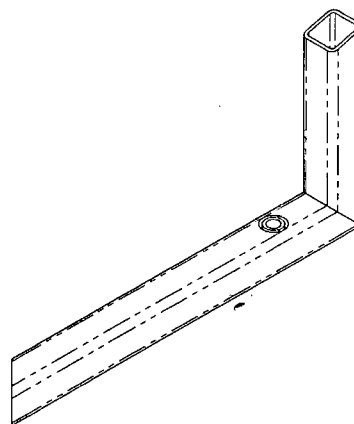
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSP G
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44294

BS10-12-1

RELEASED
08/11/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

A		NEW ISSUE		MB		08.10.08	
REV.		DESCRIPTION		BY		DATE	
DESIGN				DART AEROSPACE LTD			
DRAWN				HAWKESBURY, ONTARIO, CANADA			
CHECKED				DRAWING NO. REV. A			
MFG. APPR.				D3838 SHEET 1 OF 3			
APPROVED				TITLE SCALE			
DE APPR.				RIB ASSY (BASKET LID) NTS			
DATE				08.10.08			
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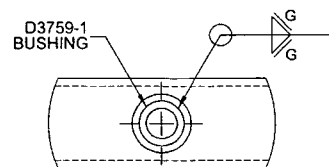
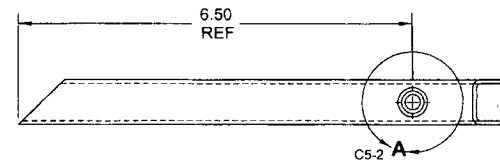
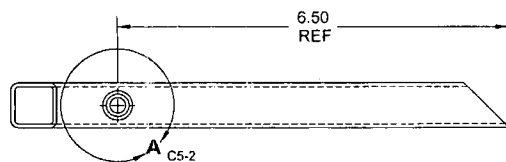
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

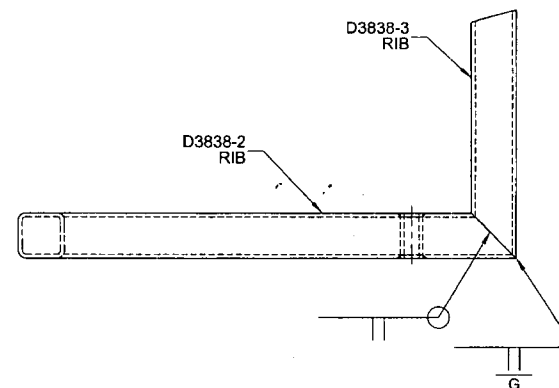
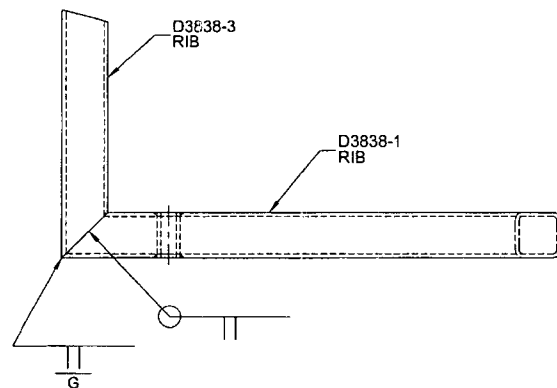
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D2-2 **DETAIL A**
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)

D3838-042 RIB ASSY (BASKET LID, LH)

w/loc4299

RELEASED
08/10/08

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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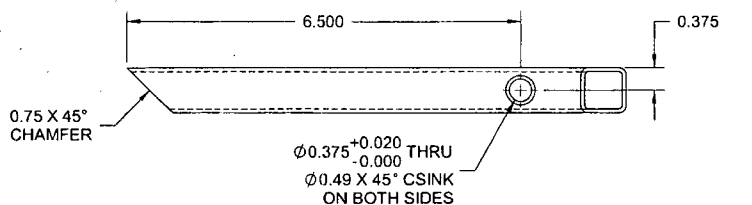
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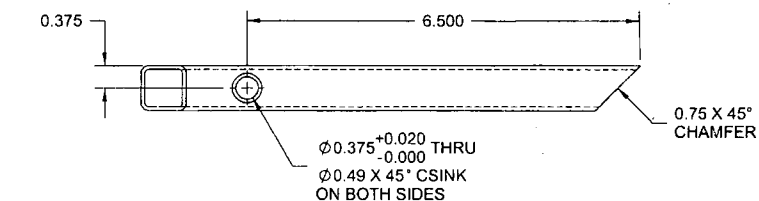
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

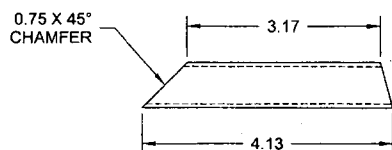
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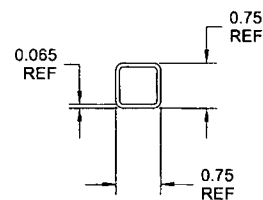
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

W/O-64289

RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3838-1/2 = 0.35 lbs EACH; D3838-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED	<i>[Signature]</i>	D3838	SHEET 3 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DATE	08.10.08		

A.

B

C

D

A

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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